

Work Order ID 76468-2

76468

November-15-11 8:11:14 AM

Page 1

Item ID: D2121

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Clamp

Start Date: 15/11/2011 Start Qty: 10.00

10

Cust Item ID:

Required Date: 29/11/2011 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: M.L.J

Date: 11/11/11

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2121

Rev D

100

100

Large Fab

Large Fab

Memo

Large Fab

Weld washer & wing nut as per Dwg D2121 & QSI 004
Identify as Wing Nut assembly

110

QC9- Inspect visual per QSI004- Fusion Welds

110

QC

Memo

Quality Control

120

120

Small Fab

Small Fab

Memo

Small Fab

Assemble parts from steps 5-14 and Wing Nut Assembly as per Dwg D2121.
Drill and deburr hole in coupling nut as per Dwg D2121.
(Note: Install MS21042L4 Nut loosely)
Cut D2771-BCFC-025-150 at 1.500"

12-3-29

FF 12-03-30

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76468

Page 2

Item ID: D2121

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Clamp

Start Date: 15/11/2011 Start Qty: 10.00

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Required Date: 29/11/2011 Req'd Qty: 10.00

10

Cust Item ID:

Reference:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC5- Inspect part completeness to step on W/O

0.00

130

QC

0.00

Quality Control

Memo

5/26/30

(47)

140

Identify as per dwg & Stock Location: 004

0.00

140

Packaging

Memo

0.00

Packaging

JB

12/03/30

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.00

Quality Control

12/4/2

MF
12-03-30

Print

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Page 1

Work Order ID: 76468

76468

Parent Item: D2121

D2121

Parent Item Name: Clamp

Start Date: 15/11/2011

Required Date: 29/11/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP: D04.05.27 Added Step 2-3; changed Step 4 KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

5/16-18 SS WING NUT Purchased No

5/16-18 SS WING NUT

Wing Nut

Location

Loc Qty

Loc Code

Mezz

123

110084

100

16016

23

5/16WC

Purchased

No

100

Each

2,548.000

1

10

5/16WC

SS Flat Washer 5/16 FW516S1

Location

Loc Qty

Loc Code

ST377

2548

115072

79

115174

47

116643

261

117332

1161

119343

1000

5/16-18 SS
THREADED

Purchased

No

120

f

0.0000

0.541

10

5/16-18 SS THREADED

Threaded Rod 6.5" long

5/16-18SS1COUPLING

Purchased

No

120

Each

20.0000

1

10

5/16-18SS1COUPLING

Coupling Nut

Location

Loc Qty

Loc Code

Mezz

20

16016

20

5/16 Jam nut

M 110084

10

10

12.03.30

Picklist Print

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Work Order ID: 76468

Parent Item: D2121

Parent Item Name: Clamp

76468
D2121

Start Date: 15/11/2011

Required Date: 29/11/2011

Start Qty: 10.00

Required Qty: 10.00

5/16WC

Purchased

No

120

Each

2,548.000

1

10

5/16WC

SS Flat Washer 5/16 FW516S1

**

Location

Loc Qty

Loc Code

ST377

2548

115072

79

115174

47

116643

261

117332

1161

119343

1000

FF 12-03-30

AN4-4A

Purchased

No

120

Each

44.0000

1

10

AN4-4A

Bolt

**

Location

Loc Qty

Loc Code

FP-B

18

114615

18

ST355

26

114615

26

10

FF 12-03-30

AN960JD416

NAS1149D0463J

Purchased

No

120

Each

0.0000

1

10

AN960JD416

Washer

D2012-107

Manufactured

No

120

Each

49.0000

1

10

D2012-107

Clevis

**

**

10

FF 12-03-30

Location

Loc Qty

Loc Code

ST004

49

71602

11

75057

38

10

FF 12-03-30

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Shop Packet Print

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Shop Packet Print

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Work Order ID: 76468

76468

Parent Item: D2121

D2121

Parent Item Name: Clamp

Start Date: 15/11/2011

Required Date: 29/11/2011

Start Qty: 10.00

Required Qty: 10.00

D2529

Manufactured No

120 Each

793.0000

D2529

Washer

Location

Loc Qty

Loc Code

ST016

793

71161

250

73486

43

76086

500

D2771-BCFC-025-150

Manufactured No

120 Each

722.0000

D2771-BCFC-025-150

Bolt

Location

Loc Qty

Loc Code

Mezz

722

8754

722

D2771-I.C.C-025

Manufactured No

120 Each

707.0000

D2771-I.C.C-025

Lock Nut

Location

Loc Qty

Loc Code

Mezz

707

4554

6

8493

701

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Picklist Print

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Work Order ID: 76468

Parent Item: D2121

Parent Item Name: Clamp

76468

D2121

Start Date: 15/11/2011

Required Date: 29/11/2011

Start Qty: 10.00

Required Qty: 10.00

MS21042L4

Purchased

No

120

Each

11,632.00

1

10

MS210421 4

Nut

**

⑦ FF12-03-30

Location

Loc Qty

Loc Code

ST300

632

117441

51

117601

374

118451

133

118927

74

ST516

6000

119017

6000

ST518

5000

119075

5000

10

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Shop Packet Print

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

D
 5/16-18 WING NUT
 5/16-18 THREADED ROD
 6.5 LONG
 5/16-18 JIM NUT
 STAINLESS STEEL
 5/16-18 1" COUPLING NUT
 D2012-107 CLEVIS
 AN4-4A BOLT
 AN960JD416 WASHER
 MS21042L4 NUT, INSTALL LOOSE
 DRILL THRU 1/4 (.250) DIA
 1.00
 0.281

D2771-BCFC-025-150 SS BOLT (1)*
 (CUT TO LENGTH AS REQUIRED)
 D2529 SS WASHER (5)*
 D2771-LCC-025 SS LOCK NUT (1)*
 *OR EQUIVALENT

RELEASED
 04-05-04



D	C	B	-	REVISION	THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMERCIAL OR CONSUMED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.	RIVET CODE SHALL BE PER NAS 623		PART NO.	ITEM	DESCRIPTION	MATERIAL	SPEC./VENDOR	
17	17	17	17	DRAWN		BASIC CODE	DA DASH NO.	CONTRACT NO.	DART DART AERO ACCESSORIES INC. VANCOUVER CANADA				
17	17	17	17	APPROVED		CH-DRAWN	LENGTH DASH NO.	DATE	DRAWN: [Signature] DATE: 12/17/1962				
17	17	17	17	DESCRIPTION OF CHANGE	REQUIREMENTS — UNLESS OTHERWISE SPECIFIED GENERAL 1. DIMENSIONS ARE IN INCHES 2. SURFACE ROUGHNESS 125 3. REMOVE SHARP EDGES .015 MAX 4. THREADS PER MIL. B. 1.742 5. HOLES PER MIL. 10187	CH-DRAWN DIGIT-NO OF SHEETS CH-DRAWN	LENGTH DASH NO. W-SPOTWELD	DESIGN	STRESS	CHECKED	CLEAR	TITLE CLAMP, BATTERY	
17	17	17	17		LIMITS 1. TOLERANCES — .001 & .002 2. ANGLES 1.0° 3. PARALLELISM .0015 4. ECCENTRICITY .005 MAX 5. SYMMETRY ABOUT ALL M/C CENTRE LINES .005	BASIC CODES B-M520470AD B-M520476AD	CODE	DWG NO.	REV	SCALE	SHT	OF	
REPORT ALL DISCREPANCIES — DO NOT SCALE													

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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